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D4682-041
Job Sheet 190777



Part No: D4682-041

Job Qty: 6 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEETS 1,4 IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM IPP REV:B 13.11.14 AS PER
DWG REV.B DD VERF:JLM IPP REV:C 14.03.13 AS PER DWG REV.PC1 DD VERF:JLM IPP REV:D 14.11.24
AS PER DWG REV.C DD VERF:JLM IPP REV:E 15.06.10 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	6 pcs		3/18/19	0.00	1.25	Waterjet - Flow		02/19/03/29
120	QC 2	6 pcs		3/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		02/19/03/29
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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130 QC 8	6 pcs	3/18/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
140 Small Fab - 2 - B4B	6 pcs	3/18/19	1.79 1.37	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 QC 5	6 pcs	3/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
160 Large Fab - Welded Assy-2-B4B	6 pcs	3/18/19	0.00 11.32	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
170 QC 9	6	3/18/19	0.00 0.00	Large Fab - 9 - B4B	
				QC 9 - 10	

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180 QC 5	6 pcs	3/18/19	0.00 0.00	QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	EL
				QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
190 Spray Paint - 2 - B4B	6 pcs	3/18/19	0.00 0.41	Spray Paint - 1 - B4B	BD 19-4-7
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 5	6 pcs	3/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
210 Packaging 3-1 - Stock - B4B	6 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	SA APR 09 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
220	QC 21 - SA	6 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 120 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 130 - (QC8- Inspect parts - second check)
 140 - (Small Fab)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Weld per dwg A/R Hardcoat S.S. Batch: _____)
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Spray Paint / NDT Room) 5156450
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	6.3600 sf (1.06 ea)	110-Waterjet - Flow - 1	5159673
D4682-9	Wearplate Shim	6 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	5167882

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S18GA	6	229	0
160-Large Fab - Welded Assy-2- B4B	D4682-9	6	5	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order:	190777
Description: Wearplate		Part Number:	D4682-1
Inspection Dwg: D4682 Rev: D			Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	<i>du</i>	Checked by:	<i>9-89</i>	QC Inspector:	
Date:	<i>19/03/29</i>	Date:	<i>MAR 29 2019</i>	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	13.05.08	New Issue	KJ	
B	15.02.26	Dimensions updated per Dwg Rev C	KJ	
C	16.05.30	Dwg Rev updated	KJ	



Container No: S167878



Part: D4682-041

Job No: 190777

Serial No/Batch: S167878

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA

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Date: 03/29/19